Work	Orde	r ID	60969
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Page 1

Tuesday, August 03, 2010 9:02:17 AM

Item ID:

D4017-041

Accept

Setup Start



Revision ID:

Item Name:

Short Basket Base Assembly (350)

Start Date:

8/4/2010

Start Qty: 1.00

Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 8/10/2010

Process Plan: MF Date: 10-8-03 Tooling:

Date: _____ SPC (Y/N):

Date:

Date:

Run Start



Stop

Stop

Sequence ID/

Operation **Work Center ID** Description Set Up/ **Run Hours**

Tool ID

Tool # Plan Code Accept Qty

Reject Reject Qty

Insp. Number Stamp

Draw Nbr

D4017

PROCEED PER HAVID CHANGES.

Weld per dwg A/R S.S. rod Batch: MI4 649 Large Fab

Revision Nbr

100

Large Fab Large Fab

Memo

0.00

1- assemble ribs, weld as per dwg D4017 using DT9610B

inspect before welding mesh

2- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary

and trim to clear fasteners holes on the ends

3- weld hinge (3) and Mounting brackets as per dwg D4017

take lid to locate hinge and bracket

110

QC Quality Control QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

B 10.08.08

0.00

W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQA		Date: _	
	R	esolution:	Disposit	Disposition: QA: N			osed:		Date: _	
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Tuesday, August 03, 2010 9:02:17 AM

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D4017-041

8/4/2010

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name: Short Basket Base Assembly (350)

Start Qty: 1.00

Req'd Qty: 1.00

Cust Item ID:

Customer:

Required Date: 8/10/2010 Reference:

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Process Plan: _____ Date: ____ Tooling:

Date:

Run Start



QC:

Date: ____

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

120

OC

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

0.00

Tool ID Tool # Plan

Code **Qty**

Reject Accept Qty

Reject Insp. Number Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Memo

Memo

0.00

Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

* Pressore work"

2ND COAT:

START TIME: 10 1000

OVEN TEMPERATURE:

FINISH TIME: 10:70A~

Dart Ae	rospace Li	td					ì			٠
W/O:			WO	RK ORDER CHAN	GES					
DATE	STEP	PR	OCEDURE CHAN	IGE		Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
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Work Order ID 60969

Page 3

Tuesday, August 03, 2010 9:02:17 AM

Item ID:

D4017-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Short Basket Base Assembly (350)

Start Date:

8/4/2010

Start Oty: 1.00

Required Date: 8/10/2010 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date: Tooling:

Operation

Date:

Tool ID

Run

Start



QC:___ Date:_____

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

140

QC

Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool # Plan Code

Accept Qty

Reject Oty

Reject Number

Insp.

Stamp

Quality Control

HandFinish

Hand Finishing

Assemble as per dwg

0.00

Memo

QC5- Inspect part completeness to step on W/O

0.00

160

Quality Control

Memo

Dart	Aero	space	Ltd
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W/O:									
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W	ork	Order	· ID	60969
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Page 4

Tuesday, August 03, 2010 9:02:17 AM

Item ID:

D4017-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Short Basket Base Assembly (350)

Start Date:

8/4/2010

QC:

Start Qty: 1.00

Required Date: 8/10/2010

Req'd Qty: 1.00



Date: _____

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date: _____ Tooling:

Date:

Date:

Start Run

Stop

Sequence ID/

Work Center ID

170

180

Packaging

Operation Description

Identify as per dwg & Stock Location: 6

Run Hours

SPC (Y/N):

Set Up/

Tool # Plan

Code

Accept **Qty**

Reject Qty

Reject Number

Insp. Stamp

Packaging

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

h 1008.4

DATE			WO	RK ORDER CHANGES	;				
	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date			Approval Chief Eng	Approva QC Inspect
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Picklist Print

Tuesday, August 03, 2010 9:02:16 AM

Work Order ID: 60969

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 8/4/2010

Required Date: 8/10/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: new issue DD 09.11.30 verified by:EC per dwg RevA DD 10.03.06 verified by:EC

IPP Rev:B as IPP Rev:C as per dwg RevB

DD 10.04.16 verified by:EC

											·		
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4017-1		Manufactured	No			100	Each	0.0000	B P	1) -> D	PD.,	YO.80.01
D4017-3 Rib		Manufactured	No			100	Each	0.0000		1 20970	DE	BD 10	108-04
D4017-5 Hinge Rib		Manufactured	No			100	Each	0.0000		1 -D973	->D	lD 10	D 08 04
D4017-7		Manufactured	No			100	Each	5.0000		1		OI OF	NO-80
				Location		Loc		Loc Code					
D4017-9		Manufactured	No	WA	58929 60473	100	5 2 3 Each	4.0000	·	<u>O</u>	 		
Rib		Manufactured			·		ı					DIOC	400BC
				<u>Location</u> WA	59984	Loc	Oty 4 4	Loc Code		<u> </u>	_ _ ·		

W/O:	T T	WORK ORDER CHANGES							
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DATE	STEP	Description of NC		Corrective Action Section			Verification	Approval	Approval
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Tuesday, August 03, 2010 9:02:16 AM

Work Order ID: 60969

Parent Item:

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 8/4/2010

2

Required Date: 8/10/2010

Start Qty: 1.00

Required Qty: 1.00

NO-10-08-04

D3916-041

Rib Assembly

D3916-5

Light Rib

Manufactured No

Manufactured

WA 60046

Location

Location

57023

60321

60545

WA

Loc Qty

Each

Each

100

100

100

9.0000

Loc Code

Loc Code

4.0000

D 10:08:04

D4034-043

D4034-041

Aft Upper Rib Assembly

Fwd Upper Rib Assembly

Manufactured

Manufactured No

No

Loc Qty 2 7

Each

3.0000

D 10.08.04

Location WA

60474 100 Loc Oty 3 3

Each

Loc Code

3.0000

10 1008 OH

Location WA

Loc Qty 3 3 Loc Code

Dart A	\eros	pace l	Ltd

W/O:			V	ORK ORDER C	HANGES					
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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Part No	.	PAR #:	Fault Ca	tegory:	N	CR: Yes	No DQA	:	_ Date: _	
	R	esolution:	lution: QA: N/C Closed:				Date:			
NCR:	*	V	VORK OR	DER NON-CONF	ORMANO	E (NCF	R)			
DATE	STEP	Description of NC		Corrective Action		Cian 6	Verifica	ion	Approval	Approval
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Tuesday, August 03, 2010 9:02:16 AM

Work Order ID: 60969 Parent Item: D4017-041 **Parent Item Name:** Short Basket Base Assembly (350) Start Date: 8/4/2010 **Required Date: 8/10/2010** Start Qty: 1.00 Required Qty: 1.00 D2581 Manufactured No 100 Each 69.0000 2 10,05.0 Mounting Bracket Location Loc Qty Loc Code WA 69 60198 34 60470 35 Each D3913-15 100 3.0000 Manufactured No D 10.080 Wide Handle Plate Location Loc Qty Loc Code WA 3 60324 3 D4016-1 Manufactured No 100 Each 9.0000 10000 OI al Hinge Half, Base Location Loc Qty Loc Code WA 9 60472 9 D4020-3 100 Each 0.0000 Manufactured No B60971-70 Mesh (350 Basket Short, Base) D4020-11 Manufactured No 100 9.0000 Each



End Mesh, Basket



Location	Loc Oty	Loc Code
WA	9	
58136	1	
59413	2 .	
60584	6	

	-									
W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRC	OCEDURE CH	ANGE	1	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Tuesday, August 03, 2010 9:02:16 AM

Work Order ID: 60969 Parent Item: D4017-041 Parent Item Name: Short Basket Base Assembly (350) D2931



46064

Start Date: 8/4/2010

Required Date: 8/10/2010

Start Qty: 1.00

Required Qty: 1.00

Bumper

Location ST504

Loc Qty 804 804

Each

Loc Code

804.0000

D4021-1

Manufactured

Manufactured

100

150

Each 21.0000

D 10,08,04

Handle	Plate		

Location		Loc Qt	¥	ţ	Loc Code
ST109			5		
57	7086		5	1	
WA			16		
60	183		4		
60	0677		12		
	1	50	Eac	h	10.0000



D4021-5

Manufactured No 150

10.0000

Blanking Plate

No

Location

60717

115016

ST111

ST351

10 10 Each

Loc Qty

55.0000

Loc Code

AN3-10A

Bolt

Location Loc Qty Loc Code 55

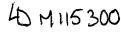
150

NAS1149DN832J Purchased AN960JD8

55 150 Each

0.0000

Washer



Purchased



W/O:			W	ORK ORDER CHANG	BES					
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Part No	•	PAR #:	Fault Ca	tegory:	NCR: `	res N	o DQA:		Date:	
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Picklist Print

Tuesday, August 03, 2010 9:02:16 AM

Page 5

Work Order ID: 60969

Parent Item:

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 8/4/2010

Required Date: 8/10/2010

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Cherry Rivets

150

1,619.000

Location Loc Qty ST321 1619 106375 3 107939 822 111636 794 Loc Code

Loc Code

MS21042L3

Purchased

Purchased

No

No

No

150

Each

Each

2,466.000

.

Nut		

Location	<u>Loc</u>	<u>Oty</u>	
ST300		2466	ï
114523		115	Ċ
114718		351	
114784		2000	
	150	Eac	ch

NAS1149F0332P

Purchased

Each

619.0000

WASHER

Location Loc Qty ST275 619 18057 619 Loc Code

Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date of the production of t

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	 Date:

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
		Description of NC		Corrective Action Section B		Verification	Approval	T
DATE STEP		Section A	Initial Chief Eng	Initial Action Description Sign &		Section C	Chief Eng	Approval QC Inspector
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QTY -041 ITEM DESCRIPTION D4017-041 SHORT BASKET BASE ASSY (350) ¥ 60969 D4017-101 TUBULAR ASSY (350 SHORT BASKET) (10)(14)(13) 2 . D2581 MOUNTING BRACKET D2931 BUMPER D3913-15 WIDE HANDLE PLATE D4016-1 3 HINGE HALF, BASE D4020-3 MESH (350 BASKET SHORT BASE) D4020-11 END MESH, BASKET D4021-1 HANDLE PLATE D4021-5 BLANKING PLATE 10 AN3-10A 6 BOLT AN960JD8 WASHER 12 2 MS20600AD4W3 RIVET 13 MS21042L3 6 NUT WASHER 14 12 NAS1149F0332P (3)(11)(12) **W**(4)

D4017-041 SHORT BASKET BASE ASSY (350) (MESH SHOWN LOCALLY FOR CLARITY)

(2)

В	NAS114	VAS AN3C10A; I9C0332R; SEC IBERED; DETAI	JPH	10.03.25		
Α		NEW ISSUE			10.03.04	٦
REV.	DESCRIPTION			BY	DATE	7
DESIGN	1	AIS	DART AEROSPA	CFI	m]∙
DRAW	1	JPH	HAWKESBURY, ONTARIO, CANADA			1
CHECK	ED	- A	DRAWING NO.		REV. E	3
MFG. A	PPR.	M	D4017		SHEET 1 OF	1
APPRO	VED	M	TITLE		SCALE	1
DE APP	R.	-#	SHORT BASKET BASE	ASSY (350) NTS	3
DATE 10.03.25 -			COPYRIGHT © 2010 BY DART AEROSPACE LTD THE DOCUMENT IS FROM TO AND COMPORTUL AND IS SUPPLIED ON THE SPIRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ODDED ON COMPANION TO TO ANY OTHER PERSON WITHOUT WITHOUT TO SELECT THE PURPOSE PURPOSE PROPERTY AND THE TOTAL ANY OTHER PERSON WITHOUT THE PURPOSE PUR			

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: 28.8 Ibs APPROX
8) INSTALL AFTER FINISH
9) MASK HOLES PRIOR TO POWDER COAT
10) WELD PER DART QSI 004

5

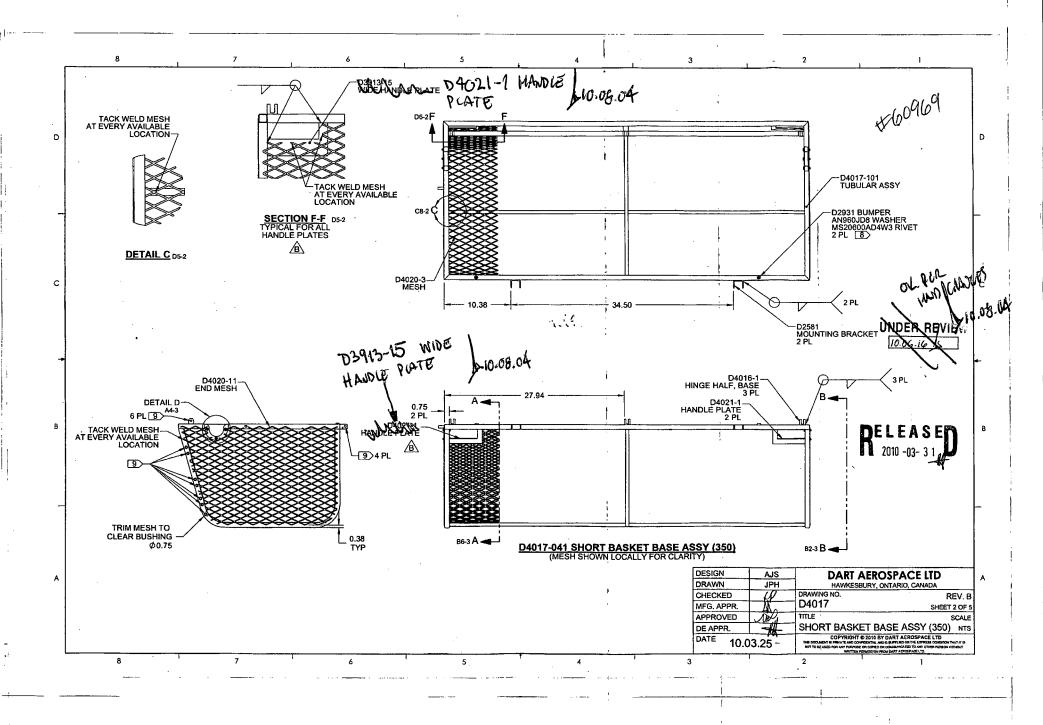
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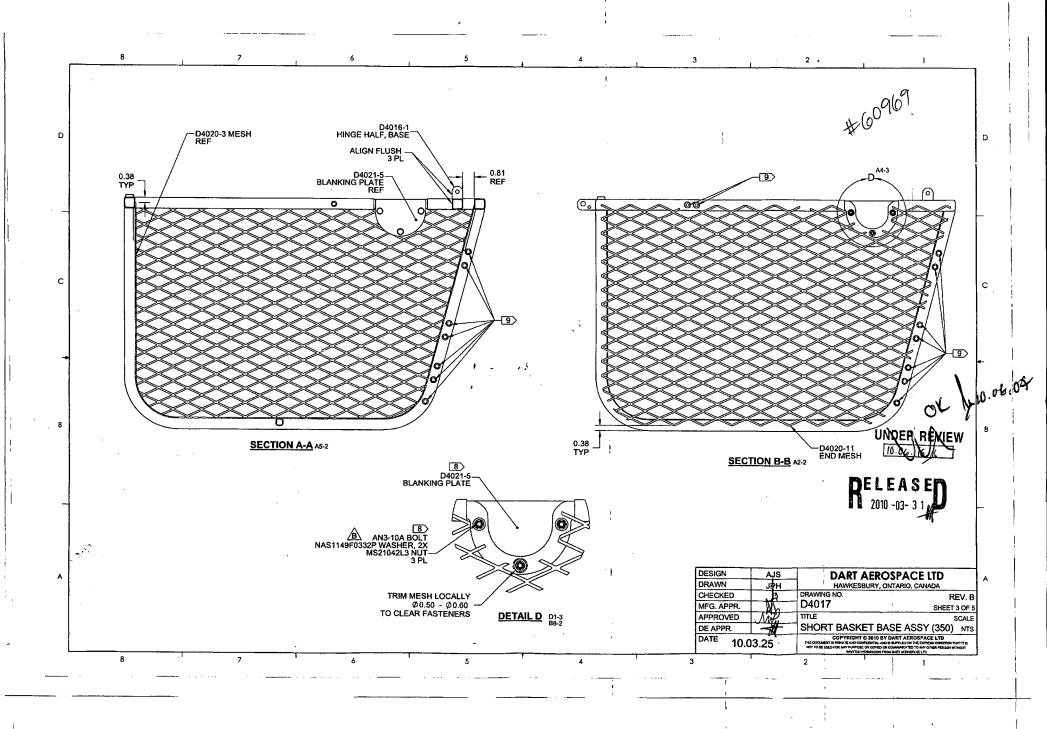
ITEM #4 INTEGERS PREVENTS

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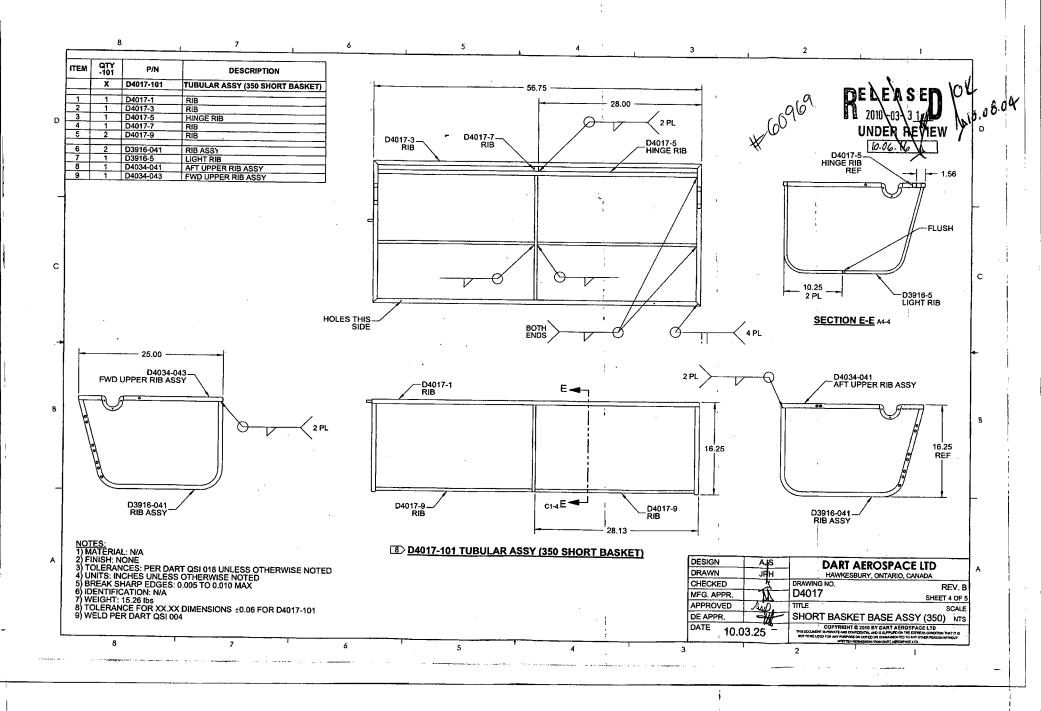
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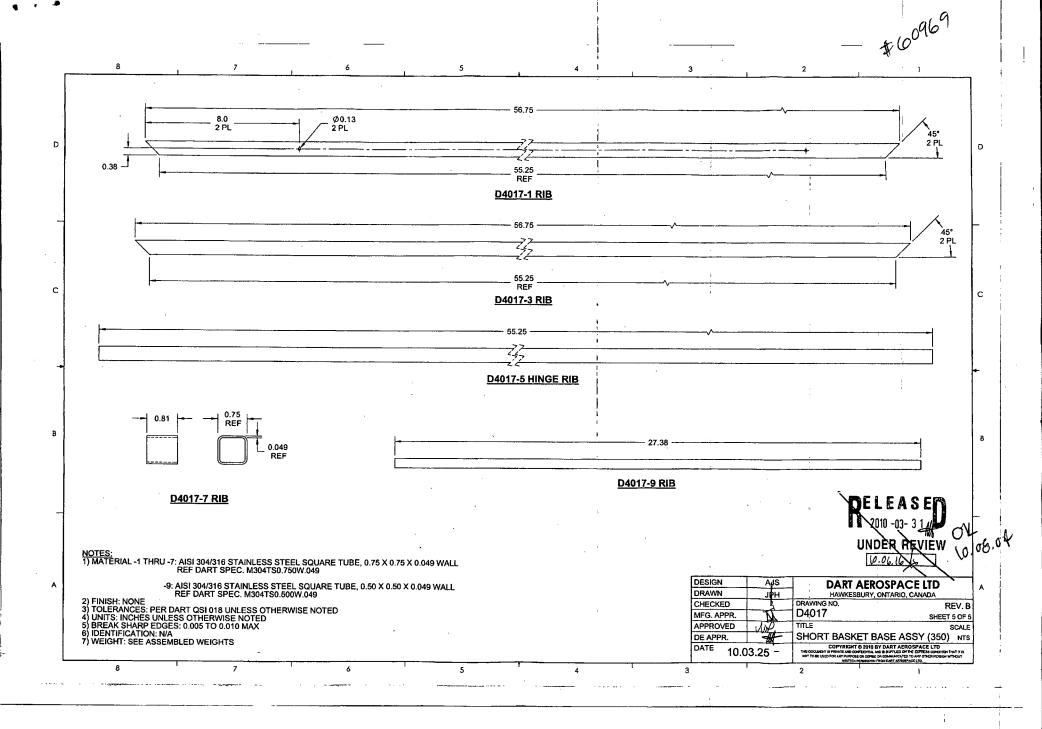
Dart Aerospace Ltd WORK ORDER CHANGES W/O: Approval **Approval d**ty **STEP** PROCEDURE CHANGE DATE By **Date** Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: _____ Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Verification **Description of NC Approval** Approval DATE STEP Sign & **Action Description** Initial Section A Section (Chief Eng QC Inspector Date Chief Eng Chief Eng



W/O:			V	VORK ORDER CHAN	IGES						
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W/O:			WO	RK ORDER CHANGES	3				
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NCR:		V	WORK ORDI	R NON-CONFOR	MANCE	(NCR)				
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